

Date: Monday, 1/7/2008 11:33:39 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001, Dart Helicopters Services Drawing Name : WHEEL ASSEMBLY
 Job Number : 36598
 Estimate Number : 12102
 P.O. Number :
 This Issue : 1/7/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : MACHINED PARTS
 Previous Run : 34638
 Part Number : D33975
 Drawing Number : D3397 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 1/23/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 08.01.07
 Comment : est rev. A New issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1020TR1375W125 COLD DRAWN ROUND TUBE



Comment: Qty.: 0.1313 f(s)/Unit Total: 1.5750 f(s)

AISI 1020-1025 ROUND TUBE

Dia. 1.375" x 0.125" wall

batch: M103258 103258 RQ 08/02/19

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

Turn as per Dwg D3397

080118 RQ 08/02/20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/02/20 (8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SF 08/02/20 (8)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CARL08/04/21 (8)

6.0 QC21 FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/22

Job Completion

2008/2/21 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

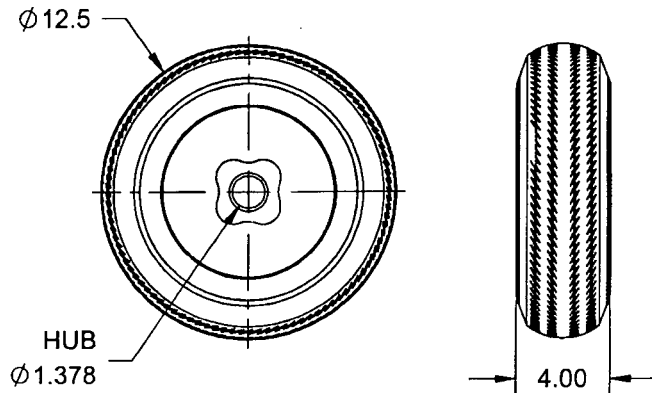
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

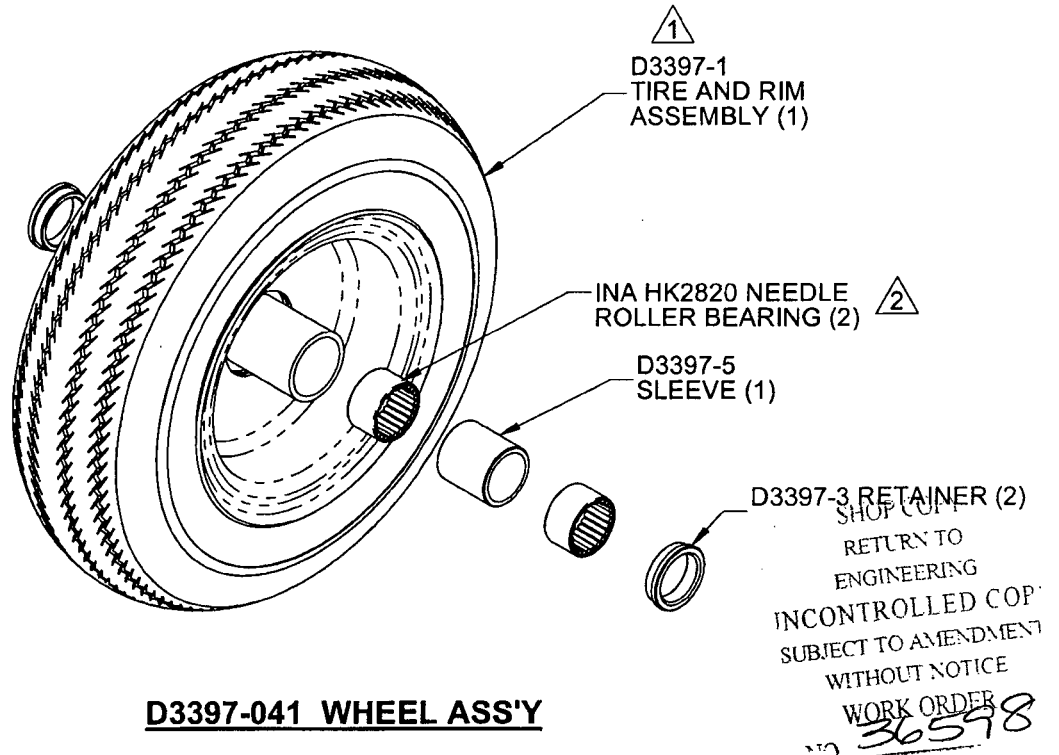
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3397	REV. A SHEET 1 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:8
A	05.02.10	NEW ISSUE	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATATION LOAD
TIRE: $\phi 12.4 \times 4.1$ RIM: $\phi 6.0 \times 4.0$	445 LBS	50 PSI*

1 D3397-1 TIRE AND RIM ASS'Y

RELEASED
06/02/07



D3397-041 WHEEL ASS'Y

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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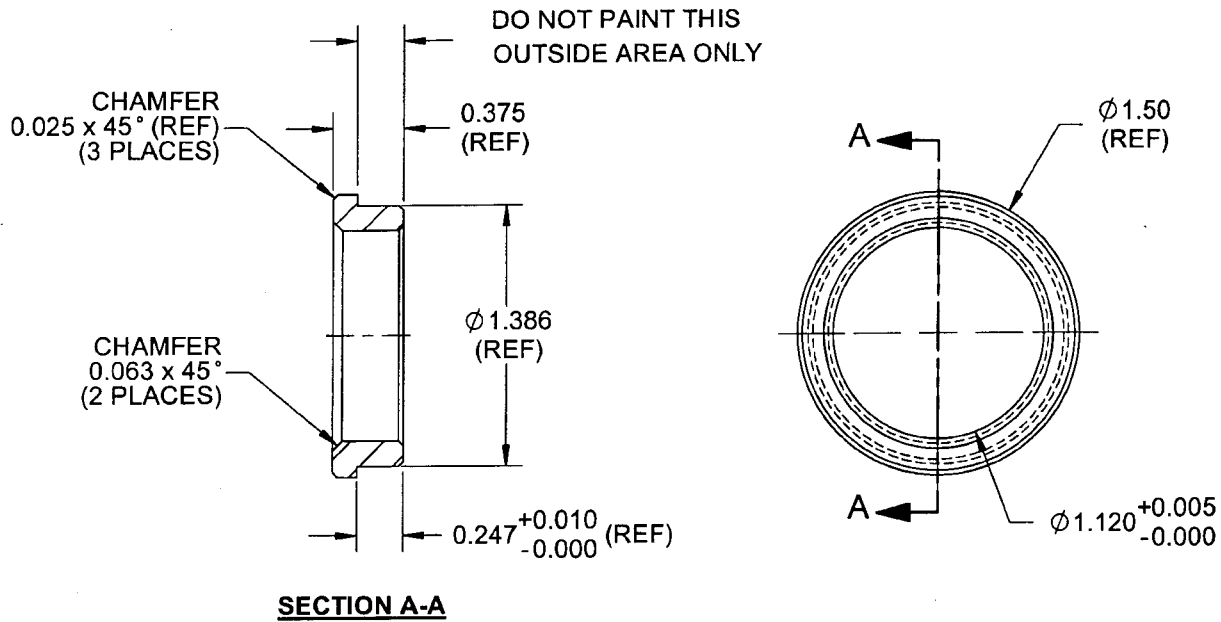
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED MB	DRAWING NO. D3397	REV. A SHEET 2 OF 3
DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
06/03/09

SPECIFICATION CONTROL DRAWING



D3397-3 RETAINER

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **36598**

NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

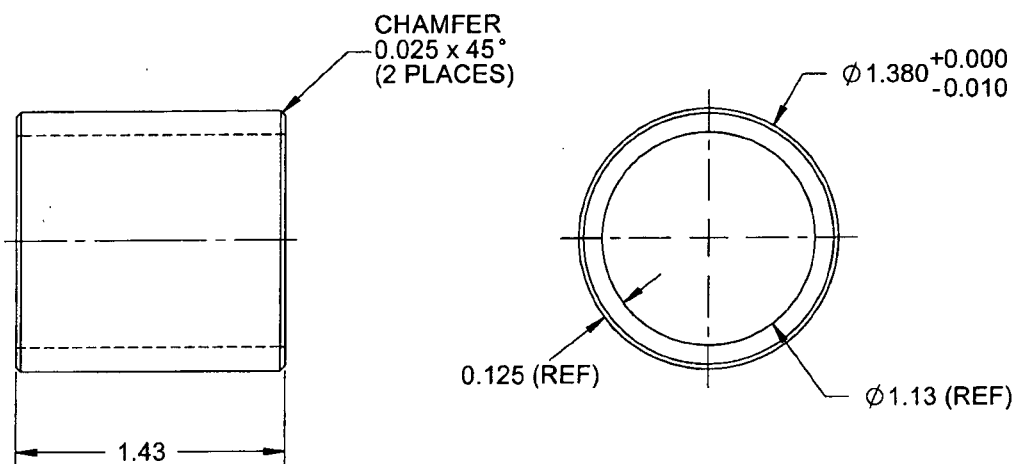
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
06/03/09



D3397-5 SLEEVE

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WORK ORDER
NO. 36598

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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